

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013764**Date Inspected:** 22-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 11DE, weld No.SSD16-PP104-252. The welder is identified as #037723. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 3F position for the OBG Segment 12AW, weld No.DP3040-001-021/022. The welder is identified as #201215. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as splice weld in between 7CE to 7DE.

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The Weld Designations are as follows

EP091-001-014
DP664-001-020
SP463-001-032
SP312-001-061
SP339-001-044
SP366-001-044
BP118-001-028
BP064-001-020,030
BP172-001-030
SP613-001-048,054
SP613-001-050
SP573-001-044,046
SP452-001-035
EP080-001-014
DP656-001-020

During the Quality Assurance Ultrasonic Testing (UT) review of splice welds located on Orthotropic Box Girder (OBG) segment 7CE to 7DE, this Quality Assurance Inspector (QA) discovered the following issues that one (1) longitudinal linear indication measuring approximately 10mm in length. The indication db's rating is +5. Material thickness is 10mm. The depth of the indications is approximately 5.5 mm. The weld is identified as SP613-001-050. The weld is designated as Non Seismic Performance Critical Members (non SPCM). The indication is clearly marked on or near the weld. The weld SP613-001-050 is a Complete Joint Penetration (CJP) butt joint, joining the Side plate "T" Stiffener to Side plate "T" Stiffener (Non SPCM). Segment 7CE and 7DE is located Trial Assembly Yard. The Notice of Witness Inspection (NWIT) No. is 005581. The indication is located outside the area previously tested by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform ten (10%) percent UT inspection of this weld.

The QA inspector did not generate any incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera, Subhasis

Quality Assurance Inspector

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Reviewed By: Patterson,Rodney

QA Reviewer